Date: Thursday, 9/14/2006 7:29:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BLOWER INLET ADAPTER
Job Number	: 28560		
Estimate Number	: 12318		
P.O. Number	: N/A	**Part Number**	: D3473043
This Issue	: 9/14/2006 **S.O. No.** : N/A	**Drawing Number**	: D3473 REV.B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: B
Previous Run	: 26990	**Material**	: N/A
Written By	:	**Due Date**	: 10/6/2006 **Qty:** ~~4~~ 2 **Um:** Each
Checked & Approved By	: 06 09 14		
Comment	: est rev. A 06.03.02 new issue EC Est Rev:B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D34735	VERTICAL TUBE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D3473-5	tube	B27019 (1) B28807 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	D34733	COVER

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D3473-3	Cover	B27018

Seq. #:	Machine Or Operation:	Description :
3.0	D34739	FLANGE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D3473-9	Flange	B26121 (1) B28509 (1)

Seq. #:	Machine Or Operation:	Description :
4.0	D34731	DUCT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D3473-1	Duct	B27017 (1) B29251 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BLOWER INLET ADAPTER

Job Number: 28560
Part Number: D3473043

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D34737	HORIZONTAL TUBE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D3473-7	Tube	~~B 27020~~ B 28588

Seq. #:	Machine Or Operation:	Description :
6.0	AN960C416L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	AN960C416L	washer	M 100651

Seq. #:	Machine Or Operation:	Description :
7.0	NAS1031C3W	Nutplate

Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
6	NAS1031C3W	Nutplate	~~M10093~~ M101144

MF 06-11-08 (2)

Seq. #:	Machine Or Operation:	Description :
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill hole as per dwg D3473 — FF 06-11-08 — 2

2-Spot weld as per dwg D3473 — MF. 06-11-07

Seq. #:	Machine Or Operation:	Description :
9.0	QC11	VISUAL INSPECTION OF SPOT WELDING

Comment: VISUAL INSPECTION OF SPOT WELDING — SB 06/11/08 (2)

Seq. #:	Machine Or Operation:	Description :
10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST351 — DB 06/11/09 (2)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes (No) DQA: [signature] Date: 06/11/10

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 28560

Part Number: D3473043

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 06/11/10

Job Completion

06-10-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

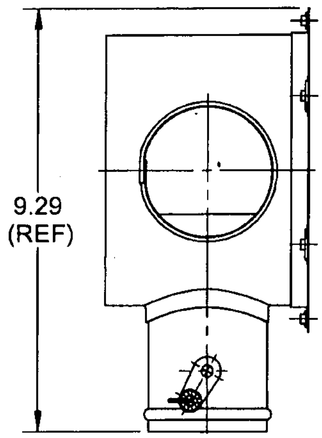
QA: N/C Closed: _____ **Date:** _________

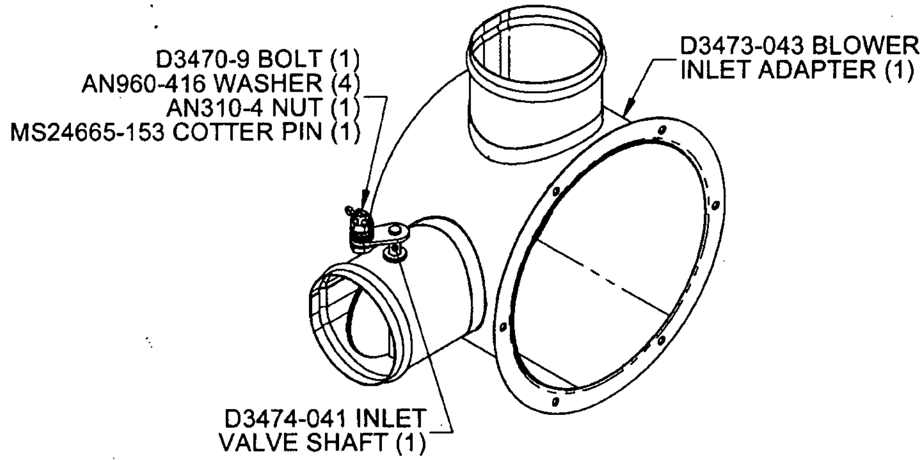
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

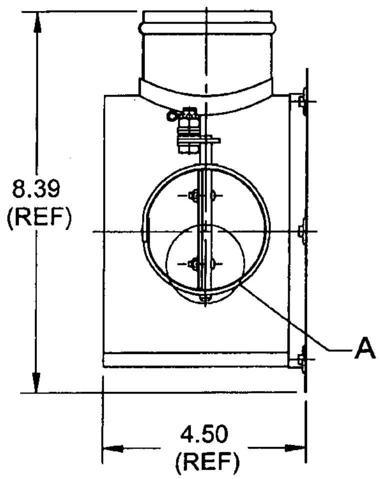
NOTE: Date & initial all entries

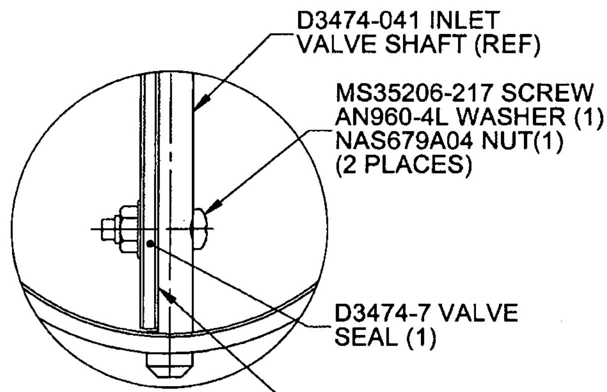
DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

DART









DETAIL A
SCALE 1 : 1

QTY -041	P/N	DESCRIPTION
X	**D3473-041**	**BLOWER INLET ADAPTER**
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

D3473-041 BLOWER INLET ADAPTER

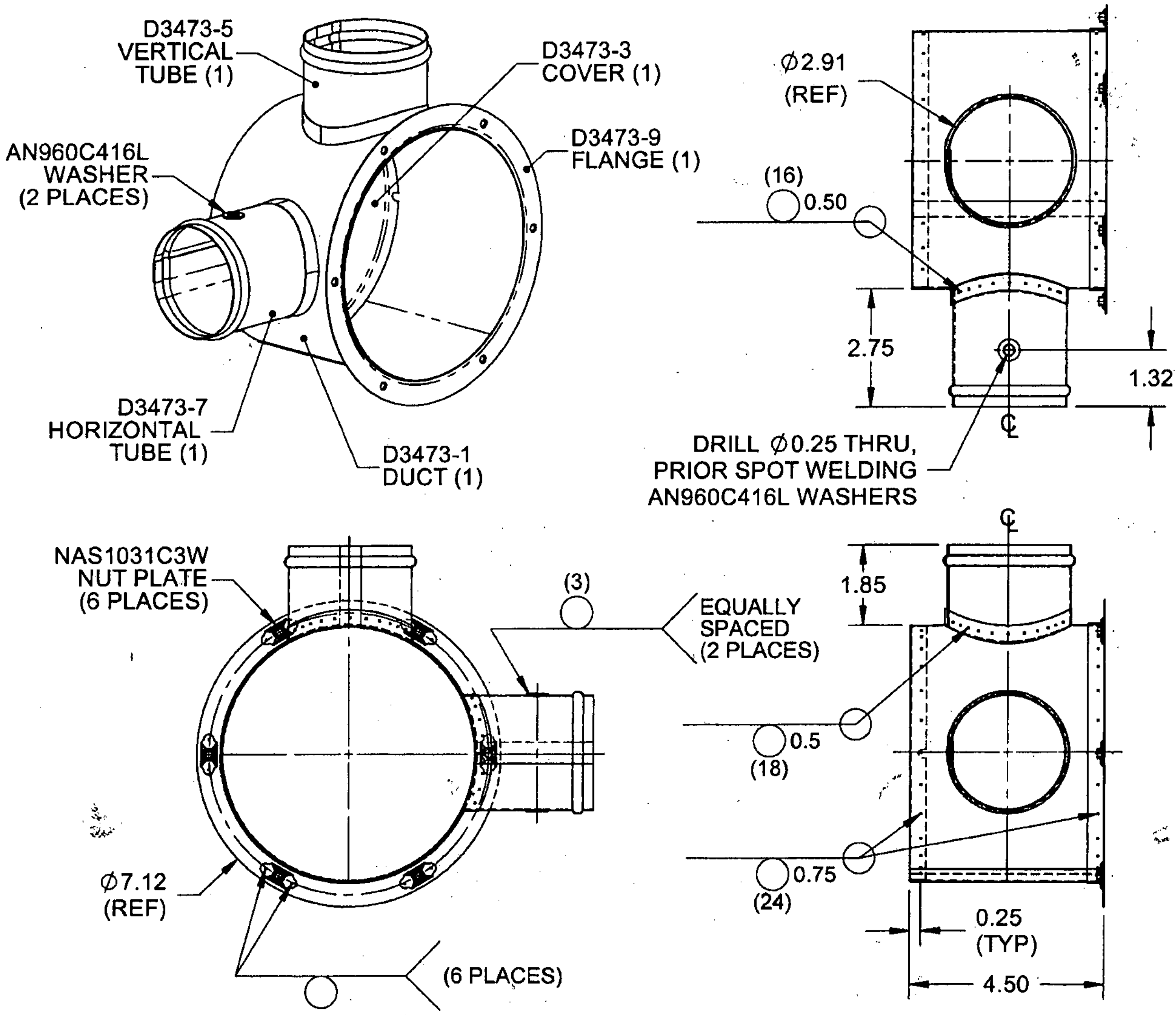
NOTES:

1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

DART

RELEASED 06.05.16



QTY -041	P/N	DESCRIPTION
X	**D3473-043**	**BLOWER INLET WELDMENT**
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

D3473-043 BLOWER INLET WELDMENT

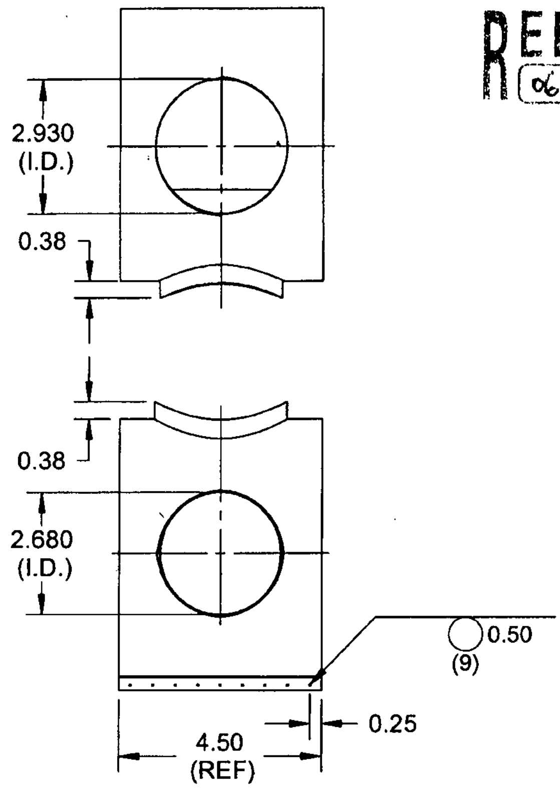
NOTES:

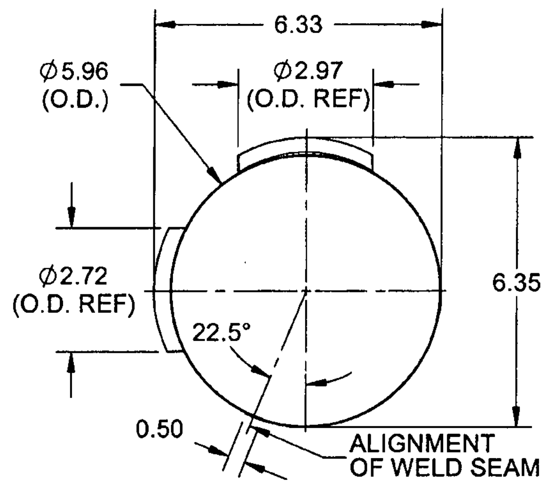
1) SPOT WELD PER DART QSI 004
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

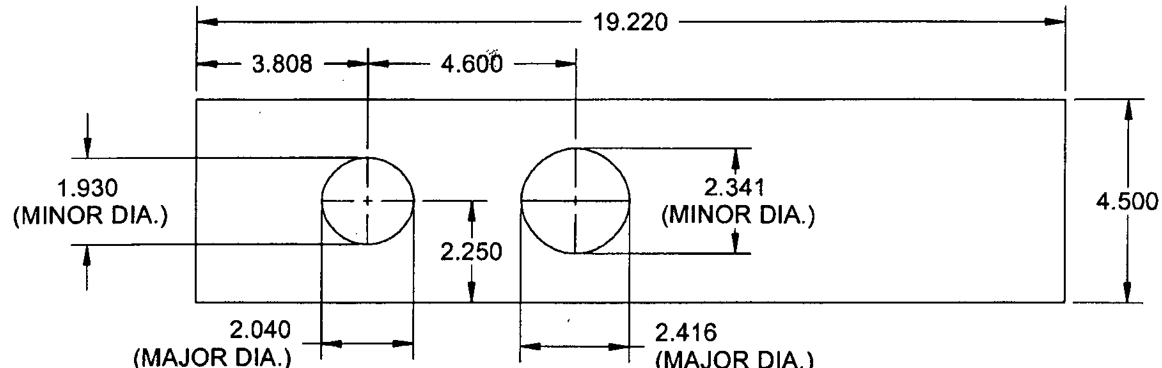
DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3473 — REV. B — SHEET 3 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER — SCALE 1:4

DART

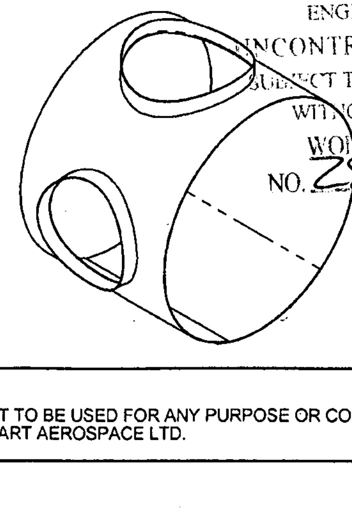
D3473-1 DUCT







D3473-1F DUCT FLAT PATTERN



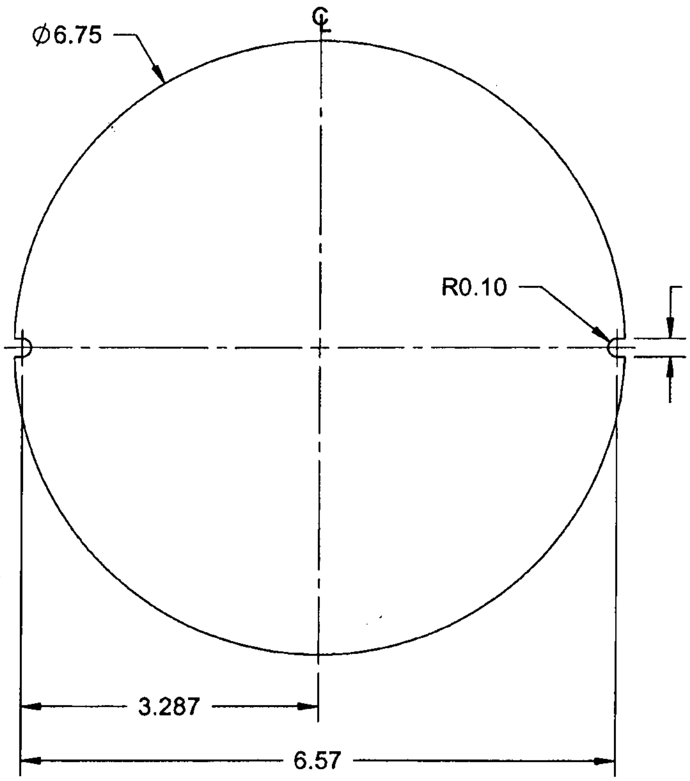
NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
   2B FINISH 26 GAUGE SS (0.018 THICK)
2) SPOT WELD PER DART QSI 004
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

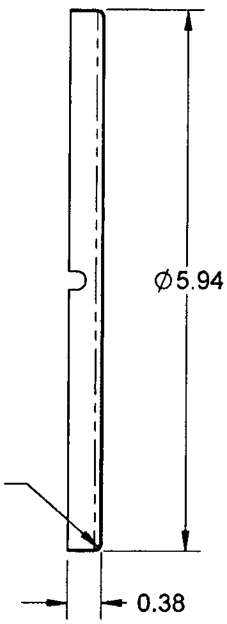
DART

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. B SHEET 4 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED 06.05.16



D3473-3F COVER FLAT PATTERN



D3473-3 COVER

NOTES:

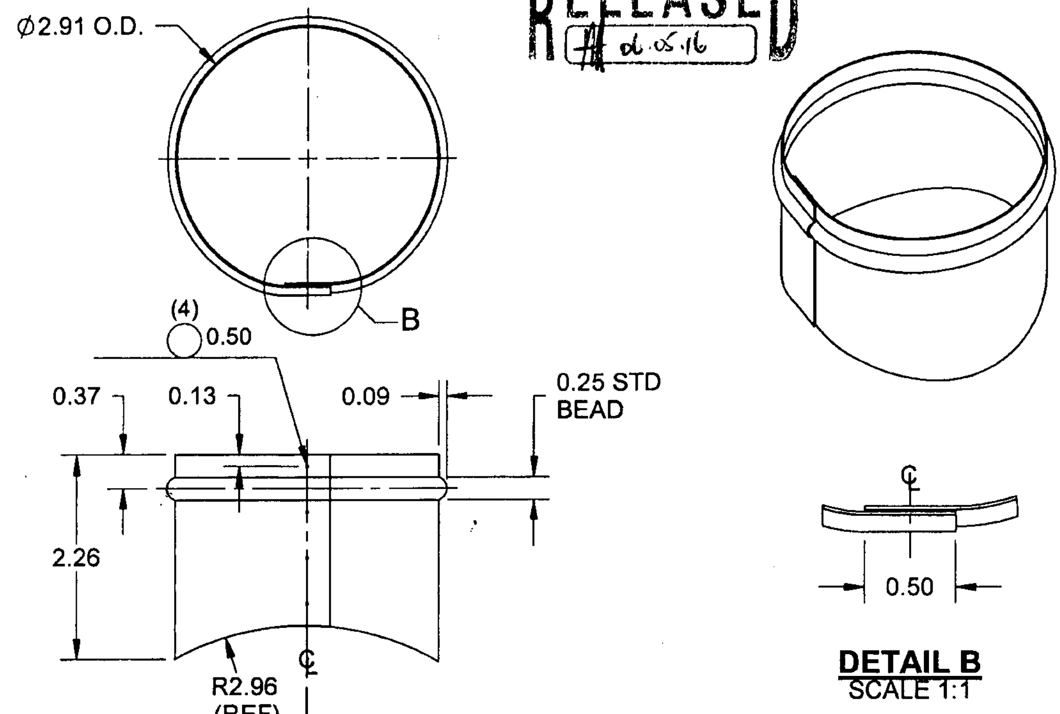
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
2) PART IS SYMMETRICAL ABOUT CENTERLINE
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. 28560

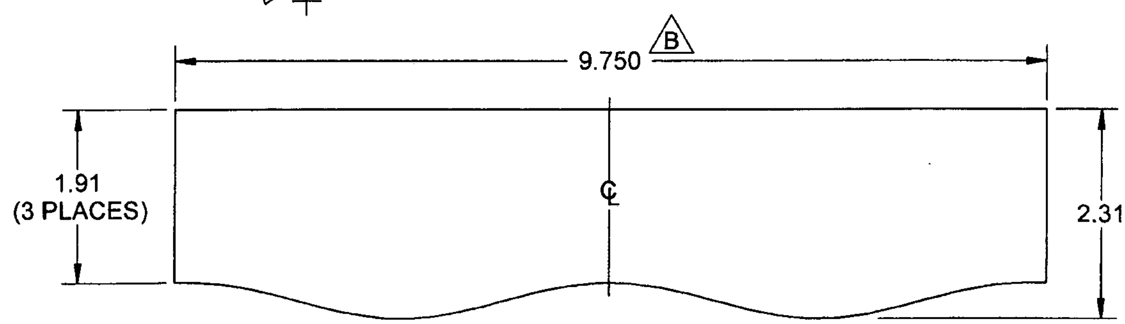
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3473 — REV. B — SHEET 5 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER — SCALE 1:2

RELEASED 06.05.16



D3473-5 VERTICAL TUBE



D3473-5F VERTICAL TUBE FLAT PATTERN

NOTES:

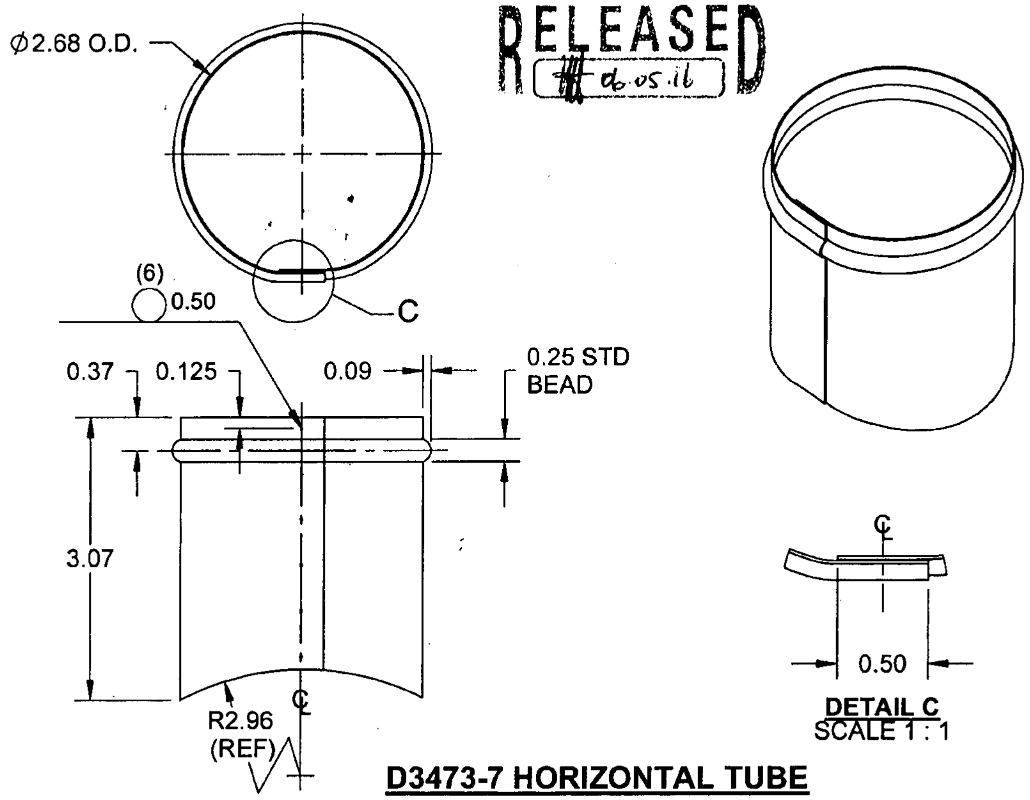
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
2) SPOT WELD PER DART QSI 004
3) FINISH: NONE
4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 28560

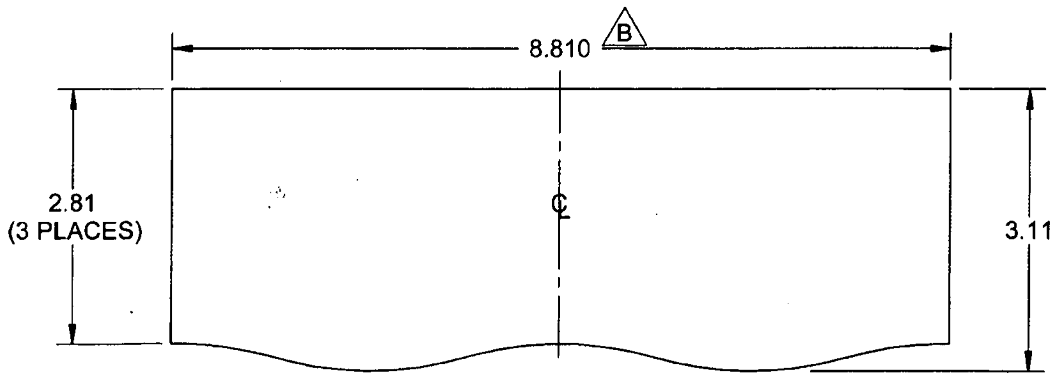
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

DART

RELEASED



D3473-7 HORIZONTAL TUBE



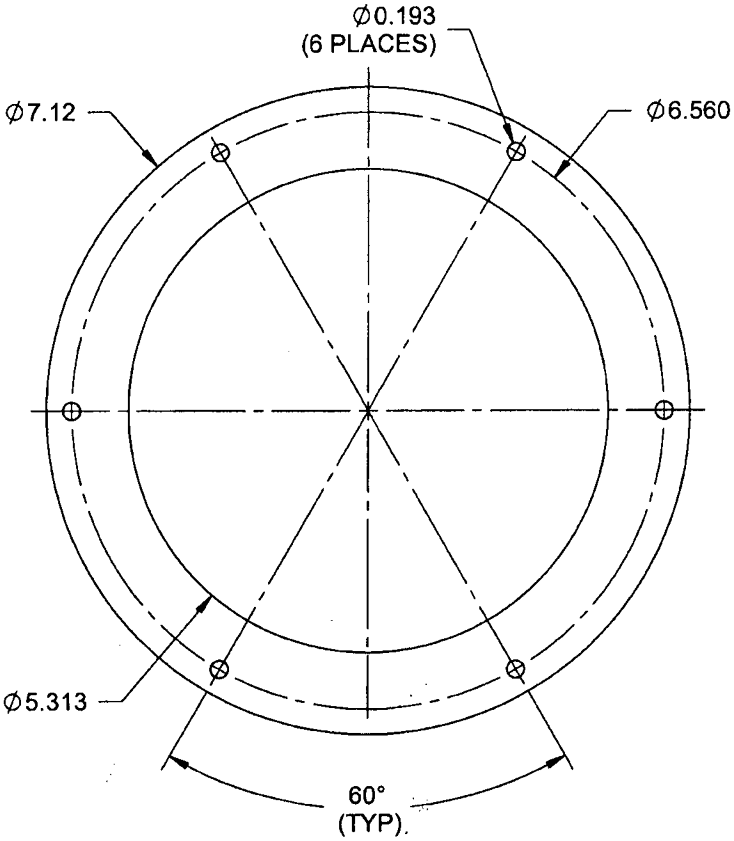
D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

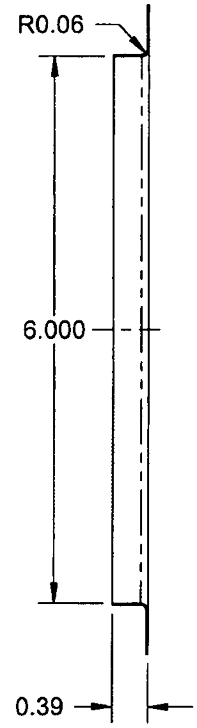
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
2) SPOT WELD PER DART QSI 004
3) FINISH: NONE
4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3473 — REV. B — SHEET 7 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER — SCALE 1:2

RELEASED 06.05.16



D3473-9F FLANGE FLAT PATTERN



D3473-9 FLANGE BENDING DETAIL

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. 28560

SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C '

TEST NO#: 9

EMPLOYEE: Melanie Fauteux

PART NUMBER: D3473-043 **JOB NUMBER:** B28560

MATERIAL TYPE: 304/316 **MATERIAL THICKNESS:** .018

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
- ☑ Group 2: Iron; nickel; cobalt
- ☐ Group 3: Titanium

TEST RESULTS

	PASS	FAIL	
VISUAL:	[✓]	[ ]	
PENETRATION:	[✓]	[ ]	
PULL STRENGTH:	[ ]	[ ]	PSI Reading: ________

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06/11/03
QUALIFIER: Sylvie Boucher